

Work Order ID 102984 -2

June-12-13 9:23:45 AM

\*102984\*

Page 1

Item ID: D3610-041

Revision ID:

Item Name: Bracket

Start Date: 6/11/13

Required Date: 6/11/13

Reference:

Start Qty: 400

Req'd Qty: 400

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 6-11-13

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3610

Rev B

100

0.00

\*100\*

Bandsaw

Leasp Bandsaw

BAND SAW

Memo

Cut blank 7.900 " long

0.00

110

0.00

\*110\*

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: B 2-Deburr per dwg D3610

0.00

120

0.00

\*120\*

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

MH

13/07/12

14

8

DAS 125

13-07-18

8

8

13-07-18

8

8





# Work Order ID 102984

June-12-13 9:23:45 AM

\*102984\*

Page 2

Item ID: D3610-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/11/13

Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 6/11/13

Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC 8- Inspect parts - second check

0.00

\*130\*

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

\*140\*

Small Fab

Memo

0.00

Small Fab

1-C SINK AS PER DWG D3610

150

QC 5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

0.00

137-22

13/07/18

8

0

08  
9-89

8

0

FF  
13-07-22

8



Work Order ID 102984

\*102984\*

Page 3

June-12-13 9:23:45 AM

Item ID: D3610-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/11/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

\*160\*

Powdercoat

Memo

0.00

Powder Coating

STAND TIME:

FINISH TIME:

OVEN TEMPERATURE:

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

180

Small Fab

0.00

\*180\*

Small Fab

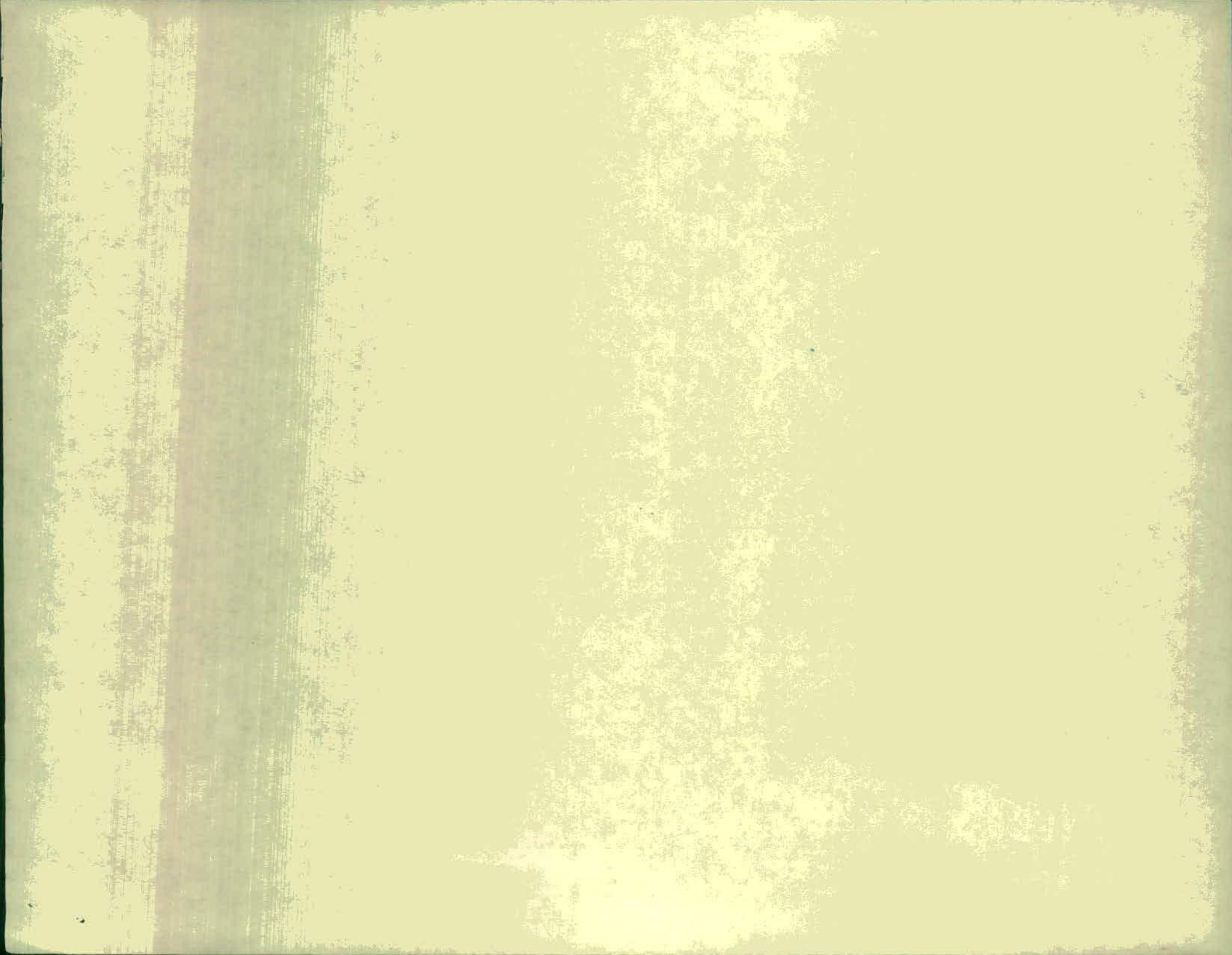
Memo

0.00

Small Fab

Rivet Nut Plate as per Dwg D3610





# Work Order ID 102984

June-12-13 9:23:45 AM

\*102984\*

Page 4

Item ID: D3610-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 6/11/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location

0.00

\*200\*

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

\*210\*

QC

Memo

0.00

Quality Control

13/7/24

13-07-23







# Picklist Print

June-12-13 9:23:45 AM

Page 1

Work Order ID: 102984

Parent Item: D3610-041

Parent Item Name: Bracket

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A new issue 07.03.28 EC  
IPP rev B released, changed mat'l EC  
VERIFIED BY:DD

IPP REV C:AS PER REV B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4140N-BK500X1.5000		Purchased	No			100	f	0.0000	0.7	2.9473684			
4140 Steel Bar 1.50 x 1.50													
MS20426AD3-4		Purchased	No			110	Each	23,568,000	2	8			
RIVET													

## Location

## Loc Qty

## Loc Code

ST334

7448

123164

7448

ST505

8000

124814

8000

ST509

8120

124586

120

125578

8000

MS21075L3

Purchased

No

180

Each

1,208,0080

1

4

Nutplate

## Location

## Loc Qty

## Loc Code

GA

203

124670

203

ST318

5

123832

5

SL507

1000

125646

1000

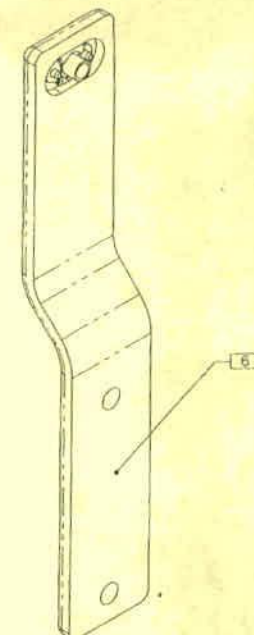
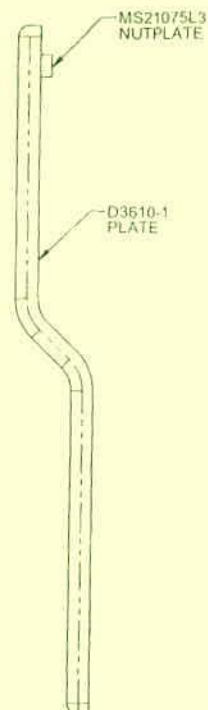
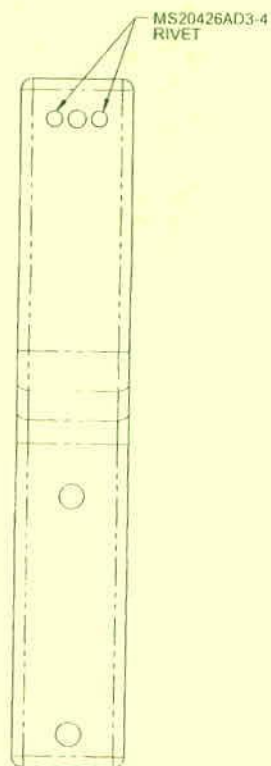
FF 13-07-23

FF 13-07-23





ITEM	QTY	P/N	DESCRIPTION
	X	D3610-041	BRACKET
1	1	D3610-1	PLATE
2	1	MS21075L3	NUT PLATE
3	2	MS20426AD3-4	RIVET



RELEASED  
2012-04-30

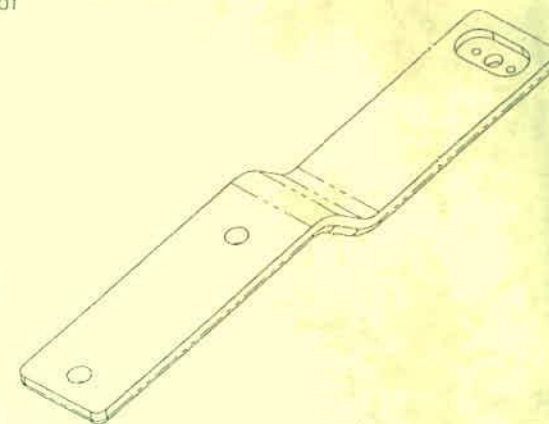
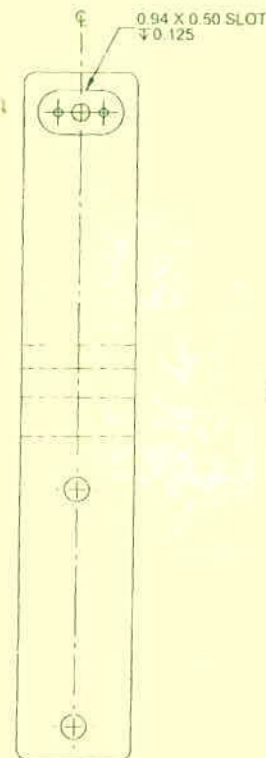
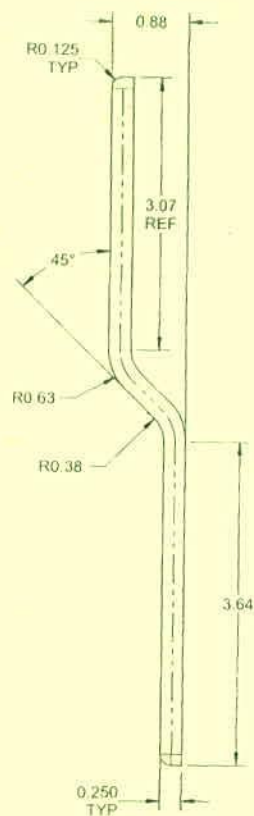
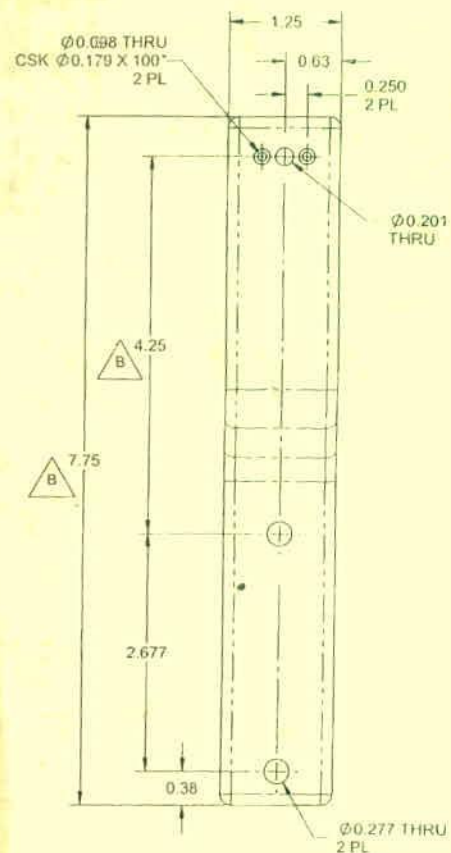
# D3610-041 BRACKET

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI D18 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3610-041" PER QSI044 METHOD 6.1
  - 7) WEIGHT: 0.62lbs

B	DIM 4.25 WAS 3.00 (CT-3) DIM 7.75 WAS 6.50 (CT-2)	RP	12.04.13
A	NEW ISSUE	LE	07.04.20
REV	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	RP	D3610	SHEET 1 OF 2
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	BRACKET	NTS
DATE	12.04.13	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE DRAWING. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	







### D3610-1 PLATE

#### NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6345 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.65lbs
- 8) PROFILE PER DRAWING FILE "D3610-1-REV B.STP"

DESIGN	LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A P	DRAWING NO.	REV. B
MFG. APPR.	FF	D3610	SHEET 2 OF 2
APPROVED	W P	TITLE	SCALE
DE APPR.	W P	BRACKET	NTS
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RELEASED  
2012-04-30





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 15244
<b>Description:</b> Plate		<b>Part Number:</b> D3610-1
<b>Inspection Dwg:</b> D3610	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.252	/		Vern	SL-10
0.250	+/-0.010	0.250	/		~	
0.63	+/-0.030	0.624	/		~	
7.75	+/-0.030	7.750	/		H-G	
4.25	+/-0.030	4.250	/		~	
2.677	+/-0.010	2.677	/		Vern	SL-10
0.38	+/-0.030	0.375	/		~	
Ø0.277	+0.006/-0.001	0.277	/		~	
Ø0.201	+0.005/-0.001	0.201	/		~	
Ø0.098	+0.004/-0.001	0.098	/		~	
0.88	+/-0.030	0.872	/		H-G	
0.94 x 0.50	+/-0.030	0.94 x 0.500	/		~	
0.250	+/-0.010	0.250	/		~	
0.125 depth	+/-0.010	0.125	/		~	

<b>Measured by:</b> XL	<b>Audited by:</b> D.A. [Signature]	<b>Preliminary Approval:</b>
<b>Date:</b> 13-7-17	<b>Date:</b> 13/07/18	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue P/O D3610-041	KJ/DD	
B	12.05.15	Dimensions updated per Dwg Rev B	KJ	[Signature]

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